



Dart Aerospace Ltd.
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D3407-5
Job Sheet 185968



Part No: D3407-5

Job Qty: 20 ea

Part Name: Ring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	11/29/18	11/29/18	0.03	1.83	Waterjet - Flow		du 15/11/09
110	QC	20 pcs	11/29/18	11/29/18	0.00	0.00	QC2		du 15/11/09
115	Lathe Conv	20 pcs	11/29/18	11/29/18	0.00	1.32	Lathe Conv-1		FRD 18-11-12
117	QC	20 pcs	11/29/18	11/29/18	0.00	0.00	QC2		FRD 18-11-12
120	QC	20 pcs	11/29/18	11/29/18	0.00	0.00	QC8		FRD 18-11-12
130	Packaging	20 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3		FRD 18-11-12
140	QC21-SA	20 Ea	11/29/18	11/29/18	0.00	0.00	QC21		21 NOV 18/11/18

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: E Prog Rev: E 2-Break edges on manual lathe Dwg D3407
Descriptions: (175rpm)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-B0.250X4.000	17-4 SS H900 Bar 0.250" X 04.000"	5.3200 ft (.266 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M17-4-H900-B0.250X4.000	5	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches ± 0.010	0.260 0.240		
2	Tow Ring	3.000inches ± 0.030	3.030 2.970		
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049		
4	Tow Ring	0.750inches ± 0.030	0.780 0.720		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



Container No: S126381



Part: D3407-5

Job No: 185968

Serial No/Batch: S126381

Revision: G

Inspector:

Exp Date:

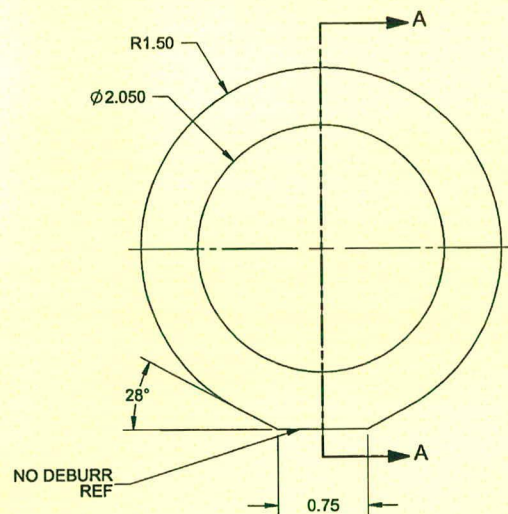
Instructions: Various STC's

Dart Aerospace Ltd.

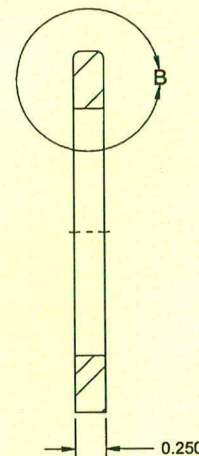
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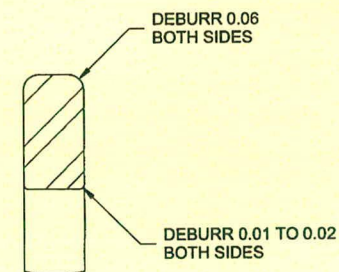
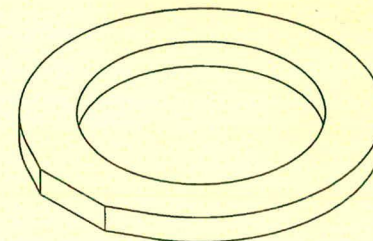
Date: 11/09/18



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

NOTES:

- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643, H900 CONDITION
MINIMUM ULTIMATE TENSILE STRENGTH = 190 KSI
MINIMUM YIELD TENSILE STRENGTH = 170 KS
REF. DART SPEC M17-4-H900-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

RELEASED
2017-10-31

APPROVED

DART AEROSPACE USA, INC.		
DESIGN	CP	EUGENE, OR
DRAWN	NO	
CHECKED	CP	DRAWING NO. REV. G
MFG. APPR.	DD	D3407 SHEET 4 OF 6
APPROVED	WM	TITLE SCALE
DE APPR.	DS	TOW RING NTS
DATE	17.09.07	

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